

# Work Order ID 68202

Friday, April 08, 2011 10:37:49 AM



Page 1

Item ID: D3219-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 4/8/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

*1104-8*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3219

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3219

*6061 . 178*

Dwg Rev: *A*

Prog Rev: *A*

*11-4-11*

*(100)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*11-4-11*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*8/10/11*

*counted*  
*1100*

*QSP019*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 68202

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Item ID: D3219-1

Accept



Setup Start



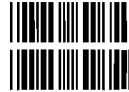
Revision ID:

Stop



Item Name: Plate

Start Date: 4/8/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 30.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Small Fab

0.00

Small Fab

Memo

Small Fab

I-Deburr if necessary.

=> (100X) M-L 11/04/11

140

0.00



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

8 u/bq/u

counts  
(x100)

150

0.00



Identify as per dwg & Stock Location: 1107

0.00

Packaging

Memo

Packaging

\*\*\* STOCK IN STEP CELL\*\*\*

11.04.27

100 /

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**Work Order ID 68202**

Friday, April 08, 2011 10:37:49 AM



Page 3

Item ID: D3219-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 4/8/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/27 JG  
ME  
11-04-27

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# Picklist Print

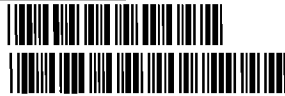
Friday, April 08, 2011 10:37:55 AM

Page 1

Work Order ID: 68202

Parent Item: D3219-1

Parent Item Name: Plate





Start Date: 4/8/2011

Required Date: 4/12/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP A 04.04.19 New issue KJ/JLM  
ESR B 06.05.25 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125  6061-T6 .125 Sheet		Purchased	No			100	sf	143.4000	0.0964	3.044211	6.5		
										18114-11			

Location

Loc Qty

Loc Code

MAT021

143.4

113608

119.4

116700

24

113608

160

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	68202
<b>Description:</b> Plate		<b>Part Number:</b>	D3219-1
<b>Inspection Dwg:</b> D3219	<b>Rev:</b> A	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.316	+0.005/-0.000	.317	✓		U R02	
2.293	+/-0.005	2.291	✓		U	
2.965	+/-0.010	2.967	✓		U	
0.566	+/-0.010	.566	✓		U	
0.375	+/-0.010	.373	✓		U	
R0.125	+/-0.010	.125	✓		R.G.	
13.9°	+/-0.5°	13.9°	✓		✓	

<b>Measured by:</b>	B	<b>Audited by:</b>	S	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	11-4-11	<b>Date:</b>	11/04/11	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	
B	07.09.06	13.9° dimension added	KJ/JLM	
C	08.04.15	0.125 dimension removed	KJ/DD	

**Dart Aerospace Ltd**

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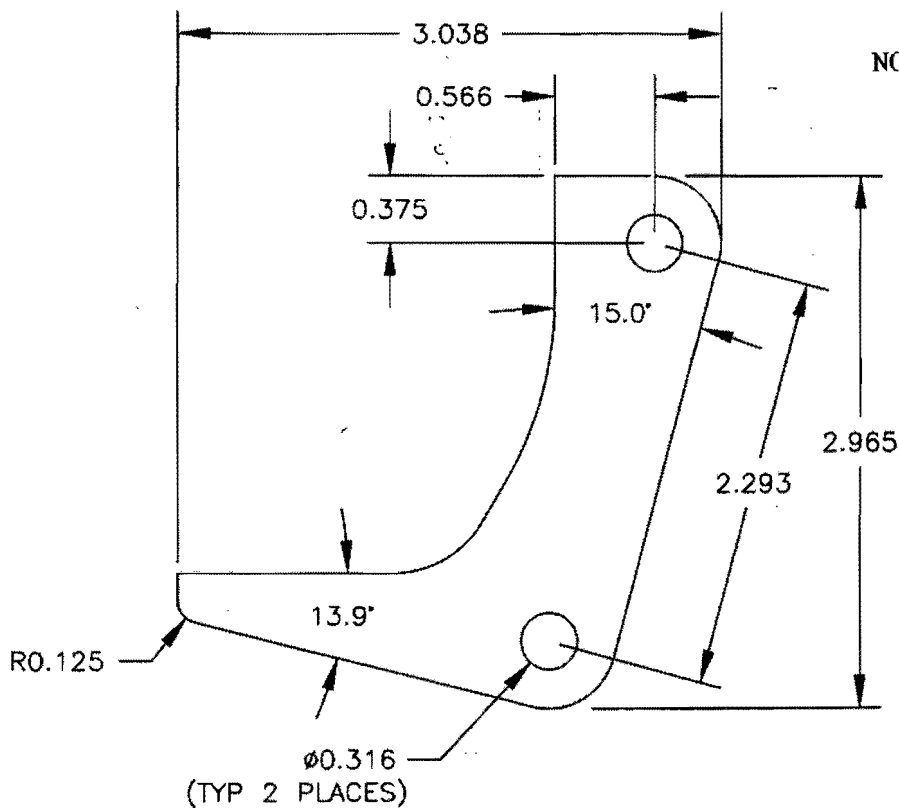


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3219	REV. A SHEET 1 OF 1
DATE 03.10.10		TITLE PLATE	SCALE 1:1
A	03.10.10	NEW ISSUE	

RELEASED  
04.04.05 *[Signature]*

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68202

*PL 11-04-8*



**D3219-1 PLATE**

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)  
(REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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# Dart Aerospace Ltd

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